

Date: Wednesday, 03/12/2008 11:28:55 AM
 User: Melanie Fauteux

Process Sheet

RUSH

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 43895	
Estimate Number : 11302	
P.O. Number :	Part Number : D34477
This Issue : 03/12/2008 S.O. No. :	Drawing Number : D3447 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 41522	Material :
Written By :	Due Date : 04/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>mf 08-12-03</u>	
Comment : Est.A 05.08.26 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1250	6061-T6 Round Bar 1.250
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Comment: Qty.: 0.4633 f(s)/Unit Total : 4.6326 f(s)
 6061-T6 Round Bar 1.250
 Material: 6061-T6 Bar Ø1.00 (QQ-A-200/8 or QQ-A-225/8)(
 M6061T6R1.250)
 Identify for D3447-7
 Batch: M109733

mf 08/12/03

①

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALLTurn as per Folio & Dwg B67-43001 Dwg Rev: NA

mf 08/12/03

①

3.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE
 Turn 3.750" dimension to Ø0.975
 Mill as per Dwg D3447
 Deburr

mf 08/12/03

①

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

mf 08/12/03

①

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

mf 08-12-03

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/12/2008 11:28:55 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 43895

Part Number: D34477

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(1X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/12/03

7.0

POWDER COATING

POWDER COATING



(1X)

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask square section

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:50
320 OF
8:20

M-L 08/12/04

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-04

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SAD 08-12-04 (1X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/04

Job Completion



MF 08-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43895
Description: Clevis		Part Number: D3447-7
Inspection Dwg: D3447 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

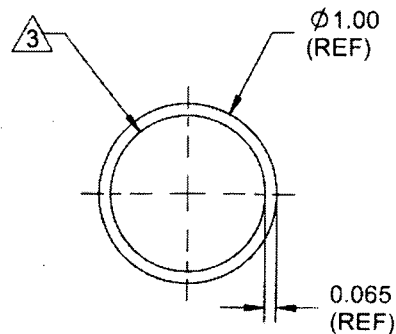
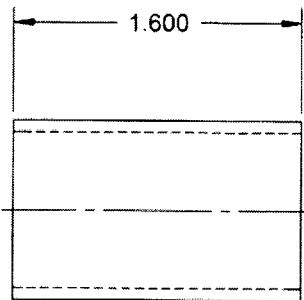
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.735	+/-0.010	.725	—			
0.735	+/-0.010	.735	—			
Ø1.130	+/-0.030	1.116	—			
2.500	+/-0.010	2.503	—			
1.225	+/-0.010	1.223	—			
0.156	+/-0.010	.157	—			
Ø0.257	+0.005/-0.000	.259	—			
5.130	+/-0.030	5.090	—			
0.350	+/-0.010	.340	—			
1.56	+/-0.030	1.517	—			
R0.130	+/-0.010	R.130	—			
0.385	+0.050/-0.000	.395	—			

Measured by: <i>mk</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 08/02/03	Date: 02-12-03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.09.19	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



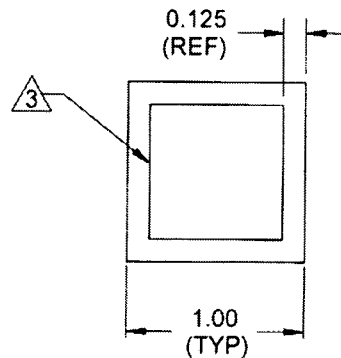
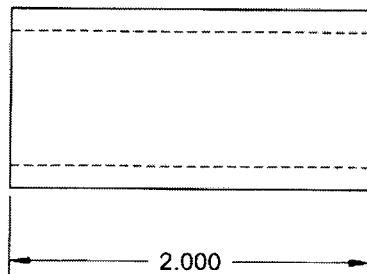
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 1 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:1
A	05.07.19	NEW ISSUE	



D3447-1 ROUND SPACER

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR
AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T1.000W.065)

REFERENCE ONLY



Nb 43895

D3447-3 SQUARE SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR
PER AMS-QQ-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6TS1.000W.125)

NOTES:

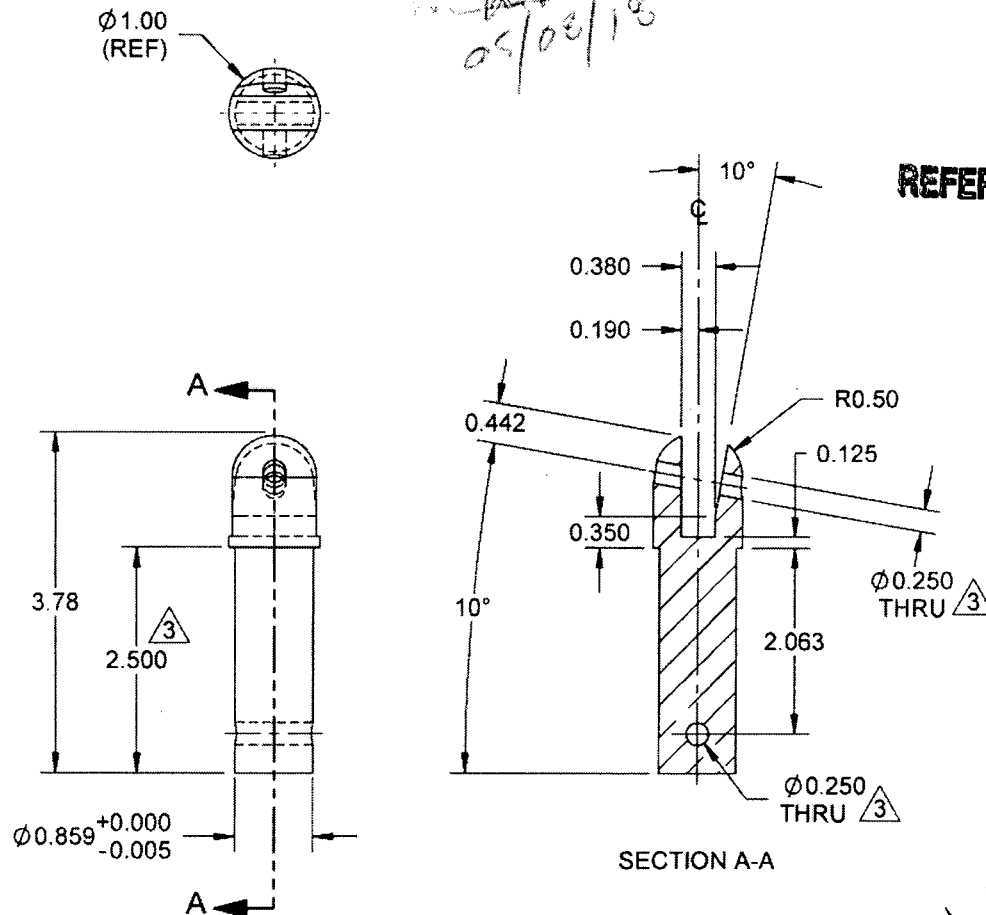
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK INSIDE OF TUBING BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 2 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2



D3447-5 CLEVIS
SUPERSEDES PREMIER P/N B67-43001-99

NOTES:

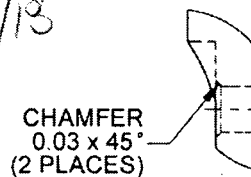
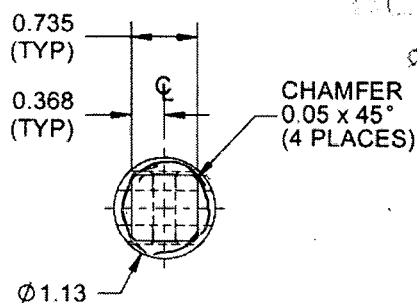
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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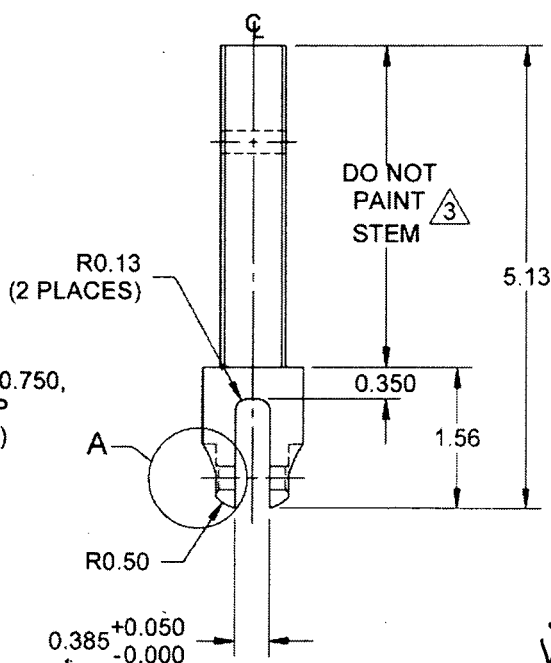
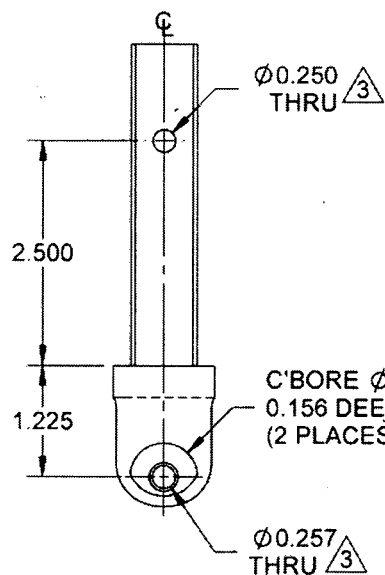


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 3 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2



REFERENCE ONLY

DETAIL A
SCALE 1:1



W 43895

D3447-7 CLEVIS

SUPERCEDES PREMIER P/N B67-43001-145/-345

NOTES:

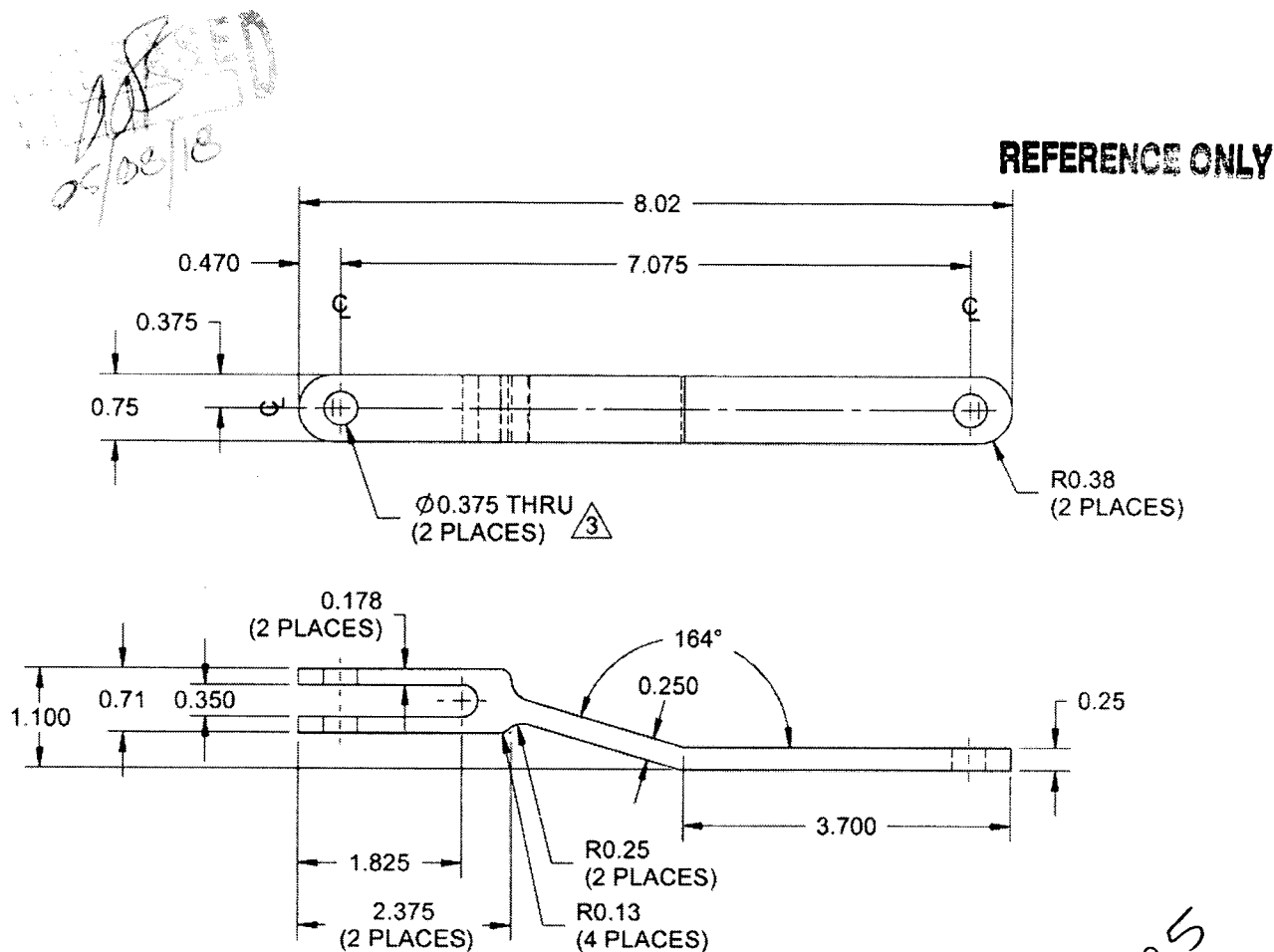
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2



D3447-9 SWING ARM
SUPERSEDES PREMIER P/N B67-43001-263

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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